

Work Order ID 130528

Friday, March 13, 2015 12:58:27 PM

130528

Page 1

Item ID: D5080-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle Bracket
Start Date: 3/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 15-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5080	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
MAR 17 2015

Work Order ID 130528

130528

Page 2

Friday, March 13, 2015 12:58:27 PM

Item ID: D5080-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle Bracket
Start Date: 3/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	12			APR 16 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(12)			DAS 38 9-89 APR 17 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>57-146</u> Memo	0.00 0.00				12	DAS 06 9-89		(12) APR 17 2015

Work Order ID 130528

Friday, March 13, 2015 12:58:27 PM

130528

Page 3

Item ID: D5080-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle Bracket
Start Date: 3/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-20
MLJ 15-04-17

Picklist Print

Friday, March 13, 2015 12:58:30 PM

Page 1

Work Order ID: 130528

130528

Parent Item: D5080-1

D5080-1

Parent Item Name: Angle Bracket

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.03.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

sf

653.2910

1

M304S18GA

02/15/03/17

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT

256

M131700

256

MAT020

397.291

124572

11.334

125552

18.0487

M126647

22.014

M128254

17.4387

M128435

27

M128864

31.5964

M129530

34.6667

M130345

11.1667

M130923

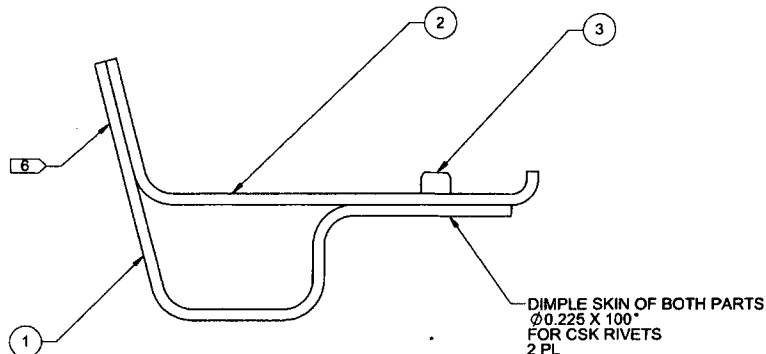
75.0424

M131384

148.9834

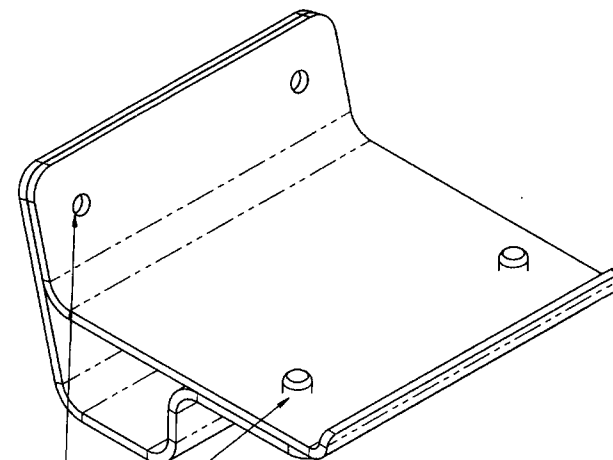
(1)

ITEM	QTY	P/N	DESCRIPTION
	X	D5080-041	STRIKER PLATE ASSY
1	1	D5080-1	ANGLE BRACKET
2	1	D5080-3	STRIKER PLATE
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D5080-041 STRIKER PLATE ASSY

TRANSFER MARK HOLES FROM D5080-3
TO D5080-1 AND DRILL Ø0.128" 4 PL



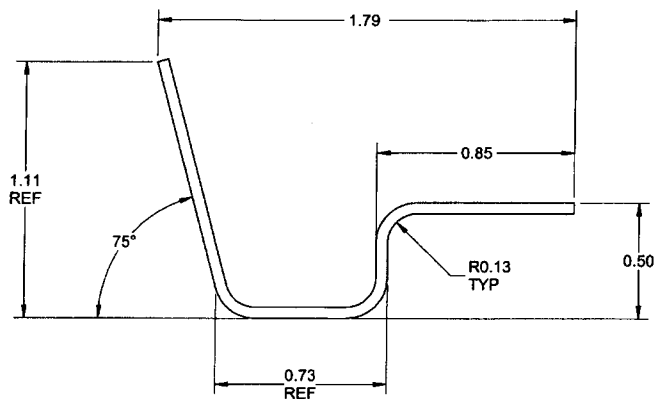
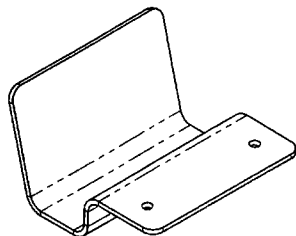
NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
 7) WEIGHT: 0.13 lbs

A		NEW ISSUE		ML	14.03.24	
REV.		DESCRIPTION			BY	DATE
DESIGN		ML		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		ML				
CHECKED		AJS		DRAWING NO.		REV. A
MFG. APPR.		DD		D5080		SHEET 1 OF 3
APPROVED		MP		TITLE		SCALE
DE APPR.		DS		STRIKER PLATE ASSY		NTS
DATE		14.03.24		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

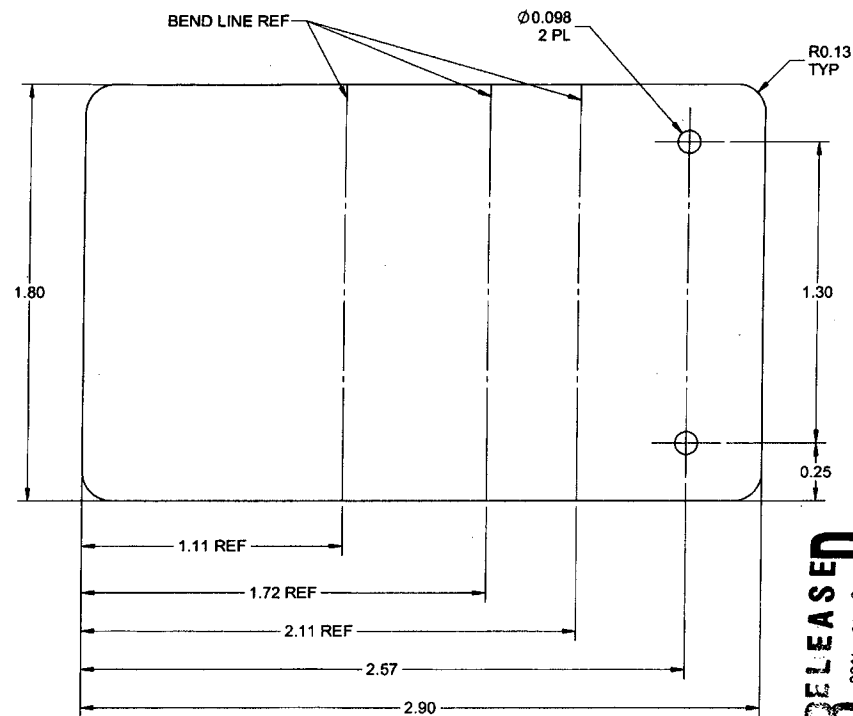
APPROVED

RELEASED
 2014-04-23

13052-8.MW
 15-03-17



D5080-1 ANGLE BRACKET
MAKE FROM D5080-1F



D5080-1F FLAT PATTERN

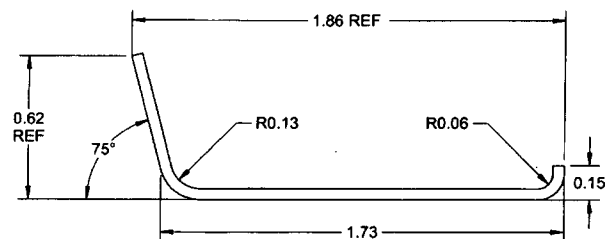
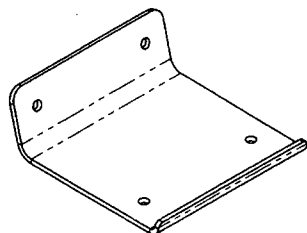
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

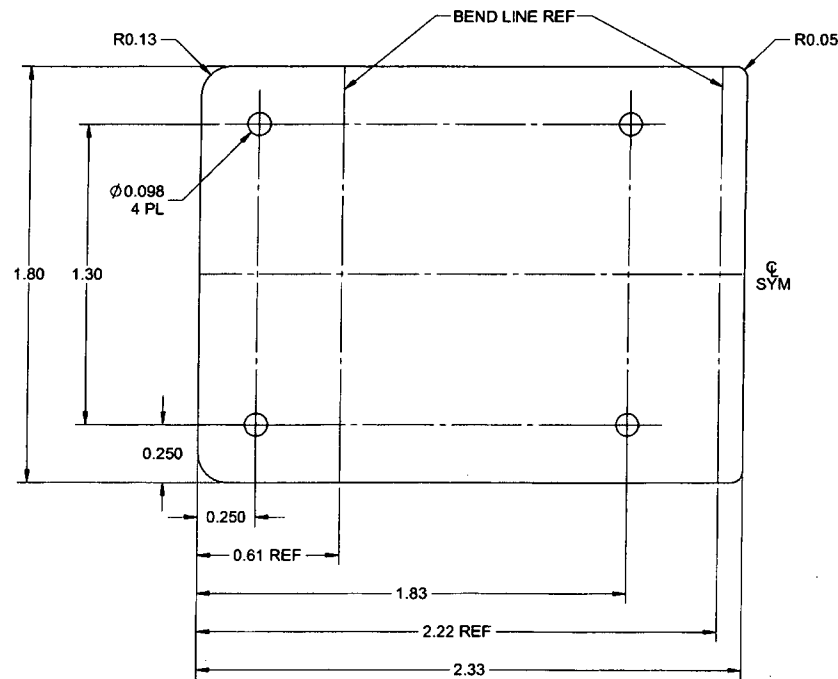
APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO. D5080	REV. A
MFG. APPR.	DD		SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRIKER PLATE ASSY	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-04-23



D5080-3 STRIKER PLATE
MAKE FROM D5080-3F



D5080-3F FLAT PATTERN

RELEASED
2014-04-23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	ML		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5080	SHEET 3 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	STRIKER PLATE ASSY	NTS
DATE		14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	